

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007992**Date Inspected:** 14-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#11

Magnetic Particle Inspection

This Q.A Inspector performed Magnetic Particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the West tower Lift4 skin 'E' Designation are as follows.

WSD1-FESA4-4F/F-28B

WSD1-FESA4-4F/F-59B

BLASTING SHOP**Visual Inspection after blasting**

This Q.A Inspector performed Visual Inspection after blasting with another QA Inspector Steve Hall of approximately 100% of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the segment 1AAE inside only.

WELDING INSPECTION REPORT

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During the Visual Inspection this QA Inspector observed various Discontinuities like Spatter, Arc strike, Porosity, Pitting, regarding this issue this QA informed to task leader and other supervisor.

This QA Inspector randomly observed the following work in progress.

BAY#11

FCAW welding process of weld joint 1 located on PCMK NSD1-A162-H/H. Welder is identified as 052075 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

TRIAL ASSEMBLY YARD

This Q.A Inspector observed ZPMC performing miss drill hole repair in segment 4AE-4BE at PP 26, 27, 28 on the stiffener where cross beam to be attached. This QA noted that ZPMC performing repair at different 12 locations with the help of WPS-345-FCAW-1G (FCM) Repair (miss drill hole).

This Q.A Inspector observed ZPMC performing sand Blasting in segment 4AE-4BE

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
